



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C10-2
Job Sheet 182090



Part No: C10-2

Job Qty: 6 ea

Part Name: Side Plate - MRK



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 7/31/18

Created By: Julien Charest-Lacombe

Type: SOLD

Description:

Note: DWG C10-2 Rev 9 IPP Rev. A 18.04.12 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Waterjet2		
100	Bandsaw	6 pcs	7/31/18	7/31/18	0.00	0.60	Bandsaw1		
120	CNC Vertical Machining	6 pcs	7/31/18	7/31/18	1.50	12.00	MORI NV5000-1		
130	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC2 Machining-5		
140	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC8 Machining-5		
150	Outsource	6 pcs	7/31/18	7/31/18	0.00	0.00	Outsource4		
160	Packaging	6 pcs	7/31/18	7/31/18	0.00	0.00	Packaging2		
170	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC6		
180	Small Fab	6 pcs	7/31/18	7/31/18	0.00	0.60	Small Fab-3		
190	QC	6 pcs	7/31/18	7/31/18	0.00	0.00	QC5		
200	Packaging	6 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3-2		
210	QC21-FG	6 Ea	7/31/18	7/31/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks to 12.50"

Descriptions: 120 - 1-Machine as per folio FC280 FOLIO REV: AA DWG REV: 9 2-Deburr
150 - Issue P/O to GROUPE ALTECH: 044245 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2
CLASS 2, Water sealant -Certificate of Conformity is required
160 - Receive
180 - Fill groves with white paint as per note 2
200 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S1.750X10.000	6061T6 SHEET 1.750 X 10.000	6.2520 ft (1.042 ea)	90-Start up Operation	SC89 472
MS21209-FI-20	HELICOL 10-32	48		SC89 900

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S1.750X10.000	6	36	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 182090
Description: SIDE PLATE - MRK		Part Number: C10-2
Inspection Dwg: C10-2 Rev: 9		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.386	±.005	Ø.385	✓		VC-pin	
.03X45°	±.010X±1/2°	.020X45°	✓		Vern H/L-08	
Ø.375	±.005	Ø.375	✓		"	
.03X45°	±.010X±1/2°	.020X45°	✓		"	
Ø.8755	±.001	Ø.8758	✓		M: CSD	
.730	±.005	.731			Vern H/L-08	
.02X45°	±.010X±1/2°	.015X45°	✓		"	
Ø.250	±.005	Ø.250	✓		"	
√.688	±.005	.693	✓		"	
.02X45°	±.010X±1/2°	.015X45°	✓		"	
Ø.576	±.001	Ø.576	✓		"	
.7493	±.0005	.7498	✓		"	
Ø.1030	±.001	1.030	✓		"	
√.735	±.005	.735	✓		"	
Ø.6234	±.0004	.6238	✓		"	
Ø.8755	±.001	Ø.8756	✓		"	
Ø.9985	±.001	.9995	✓		"	
5.87	±.010	5.870	✓		"	
1.75	±.010	1.760	✓		"	
1.44	±.010	1.433	✓		"	
6.14	±.010	6.137	✓		"	
3.44	±.010	3.435	✓			
Ø.75	±.010	Ø.751	✓		"	
7.09	±.010	7.095	✓		"	
1.250	±.005	1.255	✓		"	
.177	±.005	.177	✓		"	
.177	±.005	.177	✓		"	
R.03	±.010	R.030	✓		R-L	
.625	±.005	.6254	✓		Vern H/L-08	
.03X45°	±.010	.026X45°	✓		"	
.03X45°	±.010	.026X45°	✓		"	
.13X45°	±.010	.125X45°	✓		"	

Measured by: JMK	Checked by: Bc	QC Inspector:
Date: 18/08/20	Date: 19-04-17	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



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PURCHASE ORDER

PO043245



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO043245
PO Date: 4/18/19
Due Date: 4/26/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182090	C10-2	Side Plate - MRK -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	4/26/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00
2	192870	20NR-02	Solenoid Cover -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	21 pcs	0 pcs	21 pcs	\$4.25/pcs	\$89.25

DAS
40
9-89



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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	192957	RBE703A94-1130-01-09	Bottom Fixture 2 -Issue P/O: PO - ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2 WATER SEALANT -Certificate of Conformity is required	Firmed	-	4/26/19	6 pcs	0 pcs	6 pcs	\$5.50/pcs	\$33.00
4	189332	RBE703A94-1130-01-03	Bottom Fixture 1 -Issue P/O: PO - ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2 WATER SEALANT -Certificate of Conformity is required	Firmed	-	4/26/19	10 pcs	0 pcs	10 pcs	\$5.50/pcs	\$55.00
5	192607	RBW6521A00146W142C-3T-1	Shaft -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	4 pcs	0 pcs	4 pcs	\$4.75/pcs	\$19.00



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PO043245



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	193428	RBW6521A00146W142C-3T-2	Housing -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	4/26/19	4 pcs	0 pcs	4 pcs	\$3.95/pcs	\$15.80
Grand Total:											\$287.05

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/22/19 11:33 AM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance

(018613-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

018613- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
29-Apr-2019		Jessie Boisvert			PO043245				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir Back Order	DAS 40 9-89
1	C10-2 Rev.	C10-28A 01 -ANO-BLACK [ANODIZE BLACK] 8625F TYPE 2 CLASS 2, WATER SEALANT	ANODIZE CH	6	6	0	0	0	
2	20NR-02 Rev.	20NR-02 01 -ANO-BLACK [ANODIZE BLACK] IAW MIL-A-8625F TYPE2 CLASS 2 WATER SEALANT-MATERIAL TYPE; 6061T6	ANODIZE CH	21	21	0	0	0	
3	RBE703A94-1130-01-09 Rev.	RBE703A94-1130-01-09 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	6	6	0	0	0	
4	RBE703A94-1130-01-03 Rev.	RBE703A94-1130-01-03 01 -ANO-RED [ANODIZE RED] IAW MIL-A-8625 TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0	
5	RBW6521A00146W142C-3T-1 Rev.	RBW6521A00146W142C-3T-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	4	4	0	0	0	
6	RBW6521A00146W142C-3T-2 Rev.	RBW6521A00146W142C-3T-2 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE-2 CLASS-2	ANODIZE CH	4	4	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

DQA:

Date:

22 Nov 19/19

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>182090</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>C10-1/C10-2 REV_9</u>		Rework ☒		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☒	
NCR No. <u>19-7757</u>		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date :		Step #: <u>120</u>		QTY Effective : <u>6</u>				MRB (QSI042) Approval <u>M Lee</u> July 26, 2018			
Description Work Order Deviation				Disposition				Completed By <u>mk 18/08/22</u>			
- REPLACE TAPPED HOLES WITH HELICOIL INSERTS C10-1 SIDE PLATE -"D" HOLES QTY 8 TAP FOR 10-32 HELICOIL -"E" HOLES QTY 3 TAP FOR 1/4-28 HELICOIL C10-2 SIDE PLATE -"J" HOLES QTY 8 TAP FOR 10-32 HELICOIL				- THIS DEVIATION IS ACCEPTABLE. - THE FIT, FORM AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED.				Lead hand / Supervisor Approval Verification <u>A-e 19-04-17</u>			
								QC / QA Coordinator Approval <u>DAS</u> 68 MAY 09 2019			
Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☒	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☒	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							